

Work Order ID 86754

July-06-12 2:17:03 PM

86754

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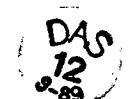

Item ID: D2322 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Step Spacer
 Start Date: 7/06/12 Start Qty: 24.00 ***24*** Cust Item ID:
 Required Date: 8/10/12 Req'd Qty: 24.00 ***24*** Customer:
 Reference:

Approvals: Process Plan: Date: 12-07-9 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2322	Rev C					57			

100 0.00
100 FLOW WATER JET
 Waterjet Memo 0.00
 FLOW CNC Waterjet 1-Cut as per Dwg D2322 Dwg Rev: C Prog Rev: C 2-
 Deburr if necessary
 2034 . 040
 110 0.00
110 QC2- Inspect parts off machine FAI/FAIB
 QC Memo 0.00
 Quality Control
 120 0.00
120 QC8- Inspect parts - second check
 QC Memo 0.00
 Quality Control
 26 →
 took qty of 1 Part
 for inspection
 DAS 16 9-59 17/07/25

Dart Aerospace Ltd

W/O: 86754		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
12/07/25	# 120	took Qtr 1 For QC inspection template	S	12/08/17	(H)	 12.08.17	 12/07/25

Part No: D 2322 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Brake NC Brake NC	NC BRAKE Memo Form as per Dwg D2322	0.00 0.00				26			SB 12/08/15
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				26			cont 12-8-15 (DAS 16 2-83) 17/06/15
150 *150* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				26			12-8-15

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC7-Inspect Chemical Conversion Coat Memo	0.00 0.00							
170 *170* Packaging Packaging	Identify as per dwg & Stock Location GA Memo	0.00 0.00							
180 *180* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

DAS
16
9-3 17/08/16

nd

SL 12/08/16

MLJ 12/08/17
MLJ 12/08/17

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Picklist Print

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Work Order ID: 86754

Parent Item: D2322

Parent Item Name: Step Spacer

Start Date: 7/06/12

Required Date: 8/10/12

Start Qty: 24.00

Required Qty: 24.00

Comments: IPP Rev:A New Issue 05-11-07 JLM
IPP Rev:B Now on Waterjet 06-07-03 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.040 2024-T3 .040 sheet		Purchased	No			100	sf	178.1612	0.203	5.1284208			

Location

Loc Qty

Loc Code

MAT022

178.1611626

120605

49.6627416

121197

32.498421

122136

96

122136

B12-7-24

(27)

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DART



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. C
BW	CP		
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 1
KE	MP	D2322	
DATE	TITLE	SCALE	
98.09.29	STEP SPACER	1:2	
A	94.10.14	NEW ISSUE	
C	98.09.29	4.428 WAS 4.460, 0.040 WAS 0.032 CHANGES PER NCR 001	

RELEASED
18.10.08 DS

UNDER REVIEW

0103.15 CP

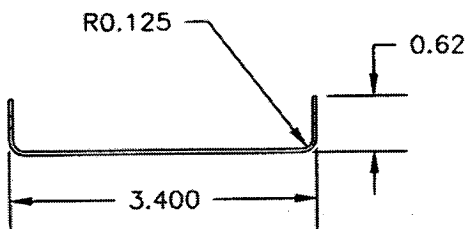
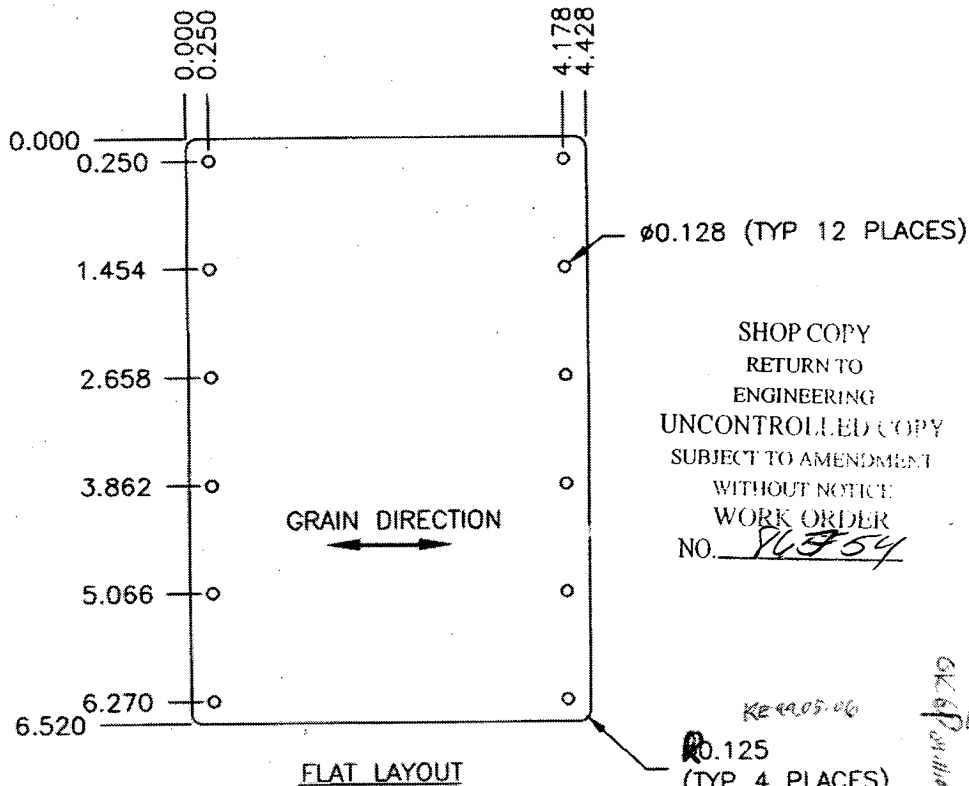
Design OK, but check with
DJS before manufacture

OK 01.11.09

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. PL 54

KE 99.05.06

R0.125
(TYP 4 PLACES)



MATERIAL: 2024-T3 (QQ-A-250/5) 0.040 THICK
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

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